Work Order ID 60518

Tuesday, July 13, 2010 11:08:54 AM

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Page 1

Item ID:

D3955-21 **Revision ID:**

Gasket

Accept

Setup Start

Stop



Start Date: Required Date: 7/20/2010

Item Name:

7/13/2010

Start Qty: 4.00 Req'd Qty: 4.00

Operation

Description

Revision Nbr

Cust Item ID:

Customer:

Tool ID

Reference: Approvals:

Sequence ID/

Draw Nbr

Work Center ID

Process Plan:

Α

Date: 10-7-13 Tooling:

Date:

Tool # Plan

Code

Run Start

QC:

Date:

SPC (Y/N):

Set Up/

Run Hours

Date:

Stop

Reject

Qty

Reject Insp. Number

Stamp

D3955 100

Waterjet FLOW CNC Waterjet

Memo

1-Cut as per Dwg D3955

Dwg Rev: Prog Rev:

2-Deburr if necessary

0.00 0.00

Accept

Qty

110

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

W/O:			W	ORK ORDER CHANG	ES						
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Work Order ID 60518 Tuesday, July 13, 2010 11:08:54 AM Item ID: D3955-21 **Revision ID:** Item Name: Gasket **Start Date:** 7/13/2010 Start Qty: 4.00 Required Date: 7/20/2010 Req'd Qty: 4.00 Reference: Approvals: Process Plan: _____ Date: ____ Tooling: QC:_____ Date:____

Operation

Description

Memo

Memo

Memo

Sequence ID/

Quality Control

120

130

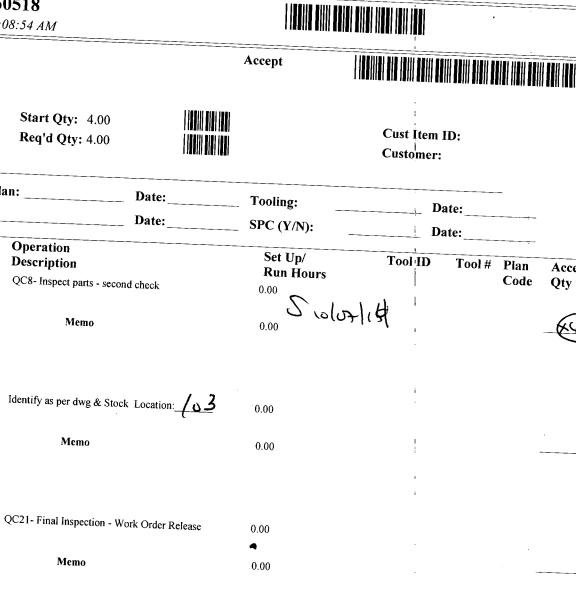
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Packaging

Packaging

Quality Control

Work Center ID



Run Start Stop Accept Reject Reject Insp. Code Qty Qty Number Stamp

Setup Start

Page 2

Part No: PAR #: Fault Category: NCR: Yes No DQA: Date: Resolution: Disposition: QA: N/C Closed: Date: NCR: WORK ORDER NON-CONFORMANCE (NCR) Date: Description of NC Corrective Action Section B Verification ApprovalApproval Approval	W/O:	ĺ		W	ORK ORDER CHANG	GES					
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Picklist Print

Tuesday, July 13, 2010 11:08:59 AM

Work Order ID: 60518

Parent Item: D3955-21

Parent Item Name: Gasket



Start Date: 7/13/2010

Start Qty: 4.00

Loc Code

Required Date: 7/20/2010

Rea

Required Qty: 4.00

Comments:

IPP RevA: New issue DD verified by:EC

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	eplacement em ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on	Qty, per Kit	Total	Qty	Date	
MNEO60S.063		Purchased	No				vieasure	Hand		Qty	Issued	Issued	Status
NEOPRENE SHEET 0.063		- m ondoog	110				sf	364.8531	0.354	1.490526		: 1	

 Location
 Loc Oty

 MAT
 259.6

 114691
 259.6

 MAT052
 105.2531

 114176
 105.2531

M

10.07.14

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Description: Gasket		9000
- 3 - 3 - 3 - 3 - 3 - 3 - 3 - 3 - 3 - 3	Part Number:	D3955-21
Inspection Dwg: D3955 Rev: A		
1.07.7.		Page 1 of 1

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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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1.283	+/-0.010	1. 283	/		M.T	
8.169	+/-0.010	8.169			M.T	
10.69	+/-0.030	10 19	U		mit	
0.063	+/-0.010	10.69 0.083	V		M.T VWN	•
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ev Date Char		101	07/14			ate: N/A
	Issue				Revised by	Approved

Dart Ae	rospace	e Ltd									
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SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 103/0-7-13 2 QTY -041 ITEM P/N DESCRIPTION X D3955-041 DOUBLER ASSY D Œ D3955-1 DOUBLER SYM MS21086L3 NUT PLATE 4 10.75 REF 2 MS20427M3-3 RIVET 10.413 DETAIL A B2-1 9.438 INSTALL MS21086L3 NUT PLATE MS20427M3-3 RIVET, 2 PL 9.188 Ø0.129 CSK Ø0.220 x 100° 19 PL 8.199 **-- 7.813** CSK SIDE-- 7.313 6.313 С D3955-1 DOUBLER-4.813 0.219 Ø0.098 CSK Ø0.175 x 100° 0.110 Ø0.201 2 PL 3.063 2.563 <u></u> © Ø 2.063 0.250 29° 1.313 Ø0.201 REF 0.613 0.0 R1.00 .750 250 375 2.38 D3955-041 DOUBLER ASSEMBLY D3955-1 DOUBLER D3955-1 NOTES:
1) MATERIAL: 6061-T6 ALUMNUM, 0.063 THICK SHEET PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N "D3955-041" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.25 lbs Α NEW ISSUE RF. REV. 09.07.21 DESCRIPTION DATE DESIGN DS, DART AEROSPACE LTD DRAWN RF HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. MFG. APPR. REV. A D3955 APPROVED SHEET 1 OF 5 DE APPR. SCALE SKIDTUBE TUNING KIT DATE COPYRIGHT © 2009 BY DART AEROSPACE LTD NTS 09.07.21 3

W/O:			WC	RK ORDER CHANG	ES					
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w/0 405/81 € SYM D 0.060 REF 10.75 D APPLY ANTI-SKID ON ONE SIDE ONLY-**8.199** 29° - 1.313 Ø0.201 2 PL 0.0 В R1.00 0.0 2.38 D3955-3 COVER PLATE NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.060 (16 GA) THICK (REF. DART SPEC. M304S16GA)
2) FINISH: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-3" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.64 lbs DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN RF CHECKED DRAWING NO. MFG. APPR. REV. A D3955 APPROVED SHEET 2 OF 5 TITLE SKIDTUBE TUNING KIT

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ils 605/8 Ø0.201 2 PL R1.00 € SYM 29° 1.31 - 10.75

D3955-X PLATE

P/N		ai Table	
D3955-5 D3955-7	T (in) 0.060 0.120	T (GA)	WEIGHT (lbs) 0.64
		 	1.28

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, T (GA) THICK (REF. DART SPEC. M304S'T'GA)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-X" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: SEE TABLE

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RF	HAMMES BURN OUT ACE	LTD
	DRAWING NO	NADA
·En	D3955	REV. A
	TITLE	SHEET 3 OF 5
-#	SKIDTURE TUNING KIT	SCALE
.21	COPYRIGHT © 2009 BY DART AEROSPA THIS DOCUMENT IS PRIVATE AND CONFIDENTIA, AND IS SUPPLED ON THE DY- NOT TO BE USED FOR ANY DRIVENS OF CONSTRUCTION.	NTS
	RF A	DRAWING NO. D3955 TITLE SKIDTUBE TUNING KIT

W/O:			W	ORK ORDER CHANGI	ES							
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W10 605/1. € SYM 0.063 REF 10.69 D Ø0.209 8.169 С 29° 1.283 Ø0.209 0.0 R0.97 0.0 2.35 **D3955-21 GASKET** D3955-21 NOTES:

1) MATERIAL: BLACK NEOPRENE SHEET, 0.063 THICK, 60 DUROMETER
(REF. DART SPEC. M-NEO60-S.063)

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-21" USING YELLOW PAINT MARKER
7) WEIGHT: 0.08 lbs DESIGN DART AEROSPACE LTD DRAWN RH HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. A MFG. APPR. D3955 SHEET 4 OF 5 APPROVED TITLE SKIDTUBE TUNING KIT

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€ SYM - 0.040 REF --- 11.13 10.600 D 9.625 9.375 8.500 8.000 Ø0.098 19 PL 7.500 - 6.500 who woods 5.000 3.250 29° 2.750 2.250 1.500 Ø0.129 2 PL 0.800 0.0 R1.19 D3955-23 TEMPLATE NOTES:
1) MATERIAL: 6061-T6 ALUMINUM, 0.040 THICK SHEET PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.040)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-23" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.16 lbs DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DS, DRAWN . RF CHECKED DRAWING NO. REV. A MFG. APPR. D3955 SHEET 5 OF 5 APPROVED TITLE SCALE DE APPR. SKIDTUBE TUNING KIT THE OCCUPENT OF THE OCCUPENT OCCUPENT OCCUPENT OCCUPENT OCCUPENT OCCUPENT OCCU NTS DATE 09.07.21 5 3

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